

Work Order ID 55020

January 5, 2010 12:59:01 PM



Page 1

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 15/01/2010 Required Qty: 24.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *PD*

Date: 10-1-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.2"

mjs
DS
10/01/14

24
+
9

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-2; 12-Deburr any rough edges

mjs
DS
10/01/14

33

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mjs
DS
10/01/14

33

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

10/01/17

33

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10-01-18

33

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-01-18

33

6

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M113170

0.00

=> M 10/01/19

(33)

φ

Powdercoat

Memo

START TIME: 7:30am
FINISH TIME: 8:00am

OVEN TEMPERATURE:
320°F

Powder Coating

170

QC3- Inspect Part Finish

0.00



BL 10-01-19

(33)

φ

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location 21

0.00



10-1-19 (33) φ

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 24.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/19 [Signature]
MK
10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:59:06 PM

Page 1

Work Order ID: 55020

Parent Item: D2857-2

Parent Item Name: Hinge Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 24.00

Required Qty: 24.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg Purchase	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	19.7474	11.0526			



6061-T6 Bar 2.00 x 1.25



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	19.74736842	
x 1105838	12	
x 110936	7.74736842	

MMU=
10/01/13

~~10.465~~
~~0.5876~~

9 x 113608

10/01/14

4.1447(F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 55020
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.302	✓			
4.000	+/-0.010	4.000	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.109	✓			
1.790	+/-0.010	1.792	✓			
1.320	+/-0.005	1.319	✓			
2.000	+/-0.010	2.000	✓			
0.340	+/-0.010	.339	✓			
0.447	+/-0.010	.443	✓			
Ø0.171	+0.005/-0.000	.174	✓			
0.147	+/-0.010	.146	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.125	✓			
0.063	+/-0.010	.063	✓			
Ø0.166	+0.005/-0.000	Ø.168	✓			
0.911	+/-0.010	.903	✓			
0.600	+/-0.010	.610	✓			
0.125	+/-0.010	.125	✓			
0.150	+/-0.010	.150	✓			

Measured by: MMS	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10/01/13	Date: 10/01/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	[Signature]

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO
WITHOUT
WORK

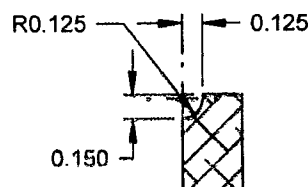
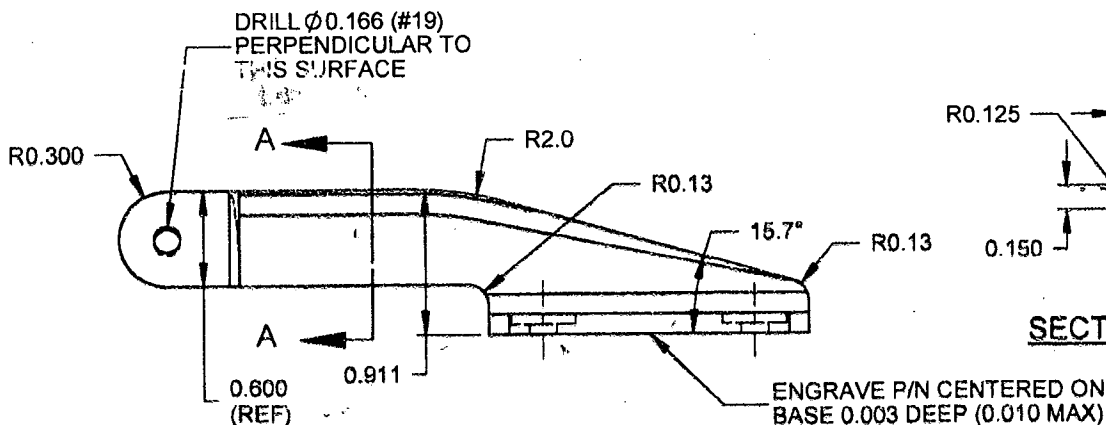
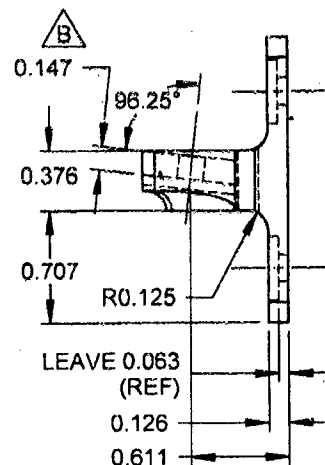
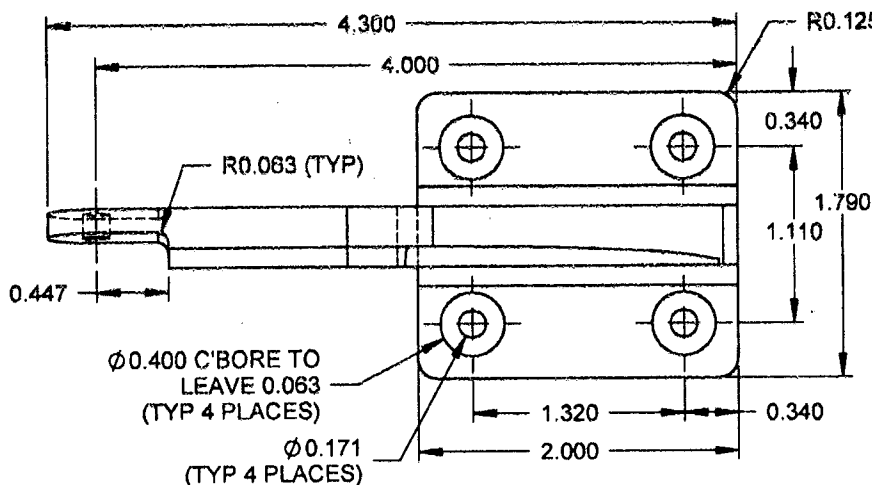
DART

NO. 55720

10-1-05

DESIGN KE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06.10.13

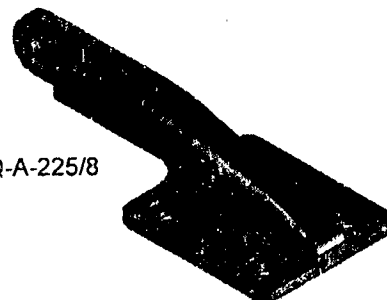


SECTION A-A

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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